Date: User: Wednesday, 03/09/2008 10:29:29 AM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41737 : 10330

Estimate Number

P.O. Number

: 03/09/2008 This Issue

: NC Prsht Rev.

First Issue

Previous Run

: // : 35496

S.O. No. :

: SMALL /MED FAB

Type

Part Number

Due Date

Drawing Name

: D2746

Drawing Number

: D2746 REV C : N/A ; C

Project Number

Drawing Revision

Material

: 30/09/2008

: WEARSHOE

Qty:

12 Um:

Each

Written By

Checked & Approved By

Comment

: Est Rev: Est Rev:

Re-format KJ

E 06-03-21

as Per Rev C JLM

Est Rev:

F 06-06-12

Now On Waterjet JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S20GA

1010/1025 SHEET



Comment: Qty.:

Total: 5.1156 sf(s)

0.4263 sf(s)/Unit 1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: 167906

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev: __C

B 8-9-15

Prog Rev:__

2-Deburr if necessary

3.0

QC2



B 8-9-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.



Page 1

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
į.										
	e de la companya de l									
Part No.		PAR #:	Fault Ca	togory.	NC	P: Vos	No DO	۸.	Date	
1 411 140		esolution:								
NCR:			WORK ORI	DER NON-CONFO	RMANCE	(NCR)			
DATE :	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descript Chief Eng	Section B tion	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
	:					·				
		· 14.3						·	į	
	1									

NOTE: Date & initial all entries

Wednesday, 03/09/2008 10:29:29 AM Date: User: 3 Julie Lecocq **Process Sheet** Drawing Name: WEARSHOE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2746 Job Number: 41737 Job Number: Description: Seq. #: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 58/09/16 1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 8.0 POWDER COATING **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING : 10.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES		•			
DATE	STEP	PR	OCEDURE CHANGE	1	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
				`	<u>L</u>				
Part No	•	PAR #:	Fault Category:	NCD.	Vac	No DO	۸.	Date:	

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:	ļ	W	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
			3					
		•						
					į		·	
			1				1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4(737)
Description: Wearshoe	Part Number: D2746
Inspection Dwg: D2746 Rev: C	Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CHE	CKLIST		
	7	First Arti	cle	Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of	Co	mments
Dimension	Tolerance	Dimension	жоорт	joot	Inspection		
0.300	+/-0.010	.301	×		_		·
1.885	+/-0.010	1.887	84				
5.450	+/-0.010	5,449	4				
10.900	+/-0.010	10.900	\$ 7				
				-			
			, ,	-			
-							
Measured by:	B	Audited by:	> ,		Prototype A		N/A
Date:	8-9-15	Date:	Orlos	l(5		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.07.07	New Issue	KJ/JLM 🚓	8



1.885

1.937

DET. B BENDING DETAIL AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W MATERIAL: SERIES STEEL, 20 GAUGE (0.040 THICK) 0.300-R0.375 R0.110 -15° R1.62 R0.375 UNICONTROLLED COPY 0.040 JOGGLE SHOP COPY RETURN TO SECTION A-A 1.000 - JOGGLE DETAIL A DETAIL B

FLAT PATTERN

21.800

DET. A

16.350

10.900 -5.450

PH)	CRAWN BY	DART AEROSPACE USA, INC.
CHECKED //	APPROVED 1	DRAWING NO. REV. C
,	*	D2746 SHEET 1 OF 1
DATE		TITLE SCALE
06.01.12		WEARSHOE 1:8
Α	98.04.16	98.04.16 NEW ISSUE
В	98.08.18	RE-DESIGN
С	06.01.12	06.01.12 ENLARGE HOLES TO IMPROVE FIT

FINISH:

MATERIAL:

DOCUMENT IS

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COPIED

AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,

38W/44W/50W/60W/70W SERIES STEEL,

20 GAUGE (0.040 THICK)

1.450

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

3) ALL DIMENSIONS ARE IN INCHES

R0.063 (TYP)

R0.25 TOOLING NOTCH (TYP)

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS PART CAN BE MADE BY MODIFYING D2656-21